

Work Order ID 56279

Wednesday, February 17, 2010 1:13:41 PM

Page 1

Item ID: D412-666-011

Accept

Revision ID:

Item Name: Gross Weight Towing

Start Date: 2/18/2010 Start Qty: 2.00

Required Date: 3/4/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *MLF*Date: *10-2-17*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-666

Rev C1

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP412-666-011

CHG 004

*5/10/14**DJ for BG 10/03/16*

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

12/4/15 (2)

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

*5/10/14**(12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop

Sequence ID/
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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-666-011 Location: ☐ PPP Rev: E

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/3/16 (2)

10/03/16

mf
10-3-16

Dart Aerospace Ltd

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Picklist Print

Wednesday, February 17, 2010 1:13:41 PM

Page 1

Work Order ID: 56279

Parent Item: D412-666-011

Parent Item Name: Gross Weight Towing

Comments: IPP Rev:B Added GHG 002 NG 02-03-06
IPP Rev:C As per Rev C JLM 07-09-07 Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6-15A 4P Bolt		Purchased	No				Each	40.0000	8.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	40	
108744	7	
111425	33	

AN6-45A 4P Bolt	Purchased	No				Each	40.0000	8.0000				
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Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	40	
110002	1	
113256	39	

AN960JD616 8P Washer	Purchased	No				Each	433.0000	16.0000				
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Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	433	
112314	3	
112828	130	
113149	300	

m114425

m113256

m113149

PC 10/3/10 (2)

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Page 2

Work Order ID: 56279



Parent Item: D412-666-011



Parent Item Name: Gross Weight Towing

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:B Added GHG 002 NG 02-03-06
IPP Rev:C As per Rev C JLM 07-09-07 Verified By:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2888 		Manufactured	No				Each	13.0000	4.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	13	
54021	1	
54497	12	

MS2104216 	
---------------	--

Purchased

No

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	388	
105077	22	
110002	5	
111578	361	

54021
54497

111578

Wednesday, February 17, 2010 1:13:41 PM

Shop Packet Print

Page 2

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1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

REFERENCE ONLY

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

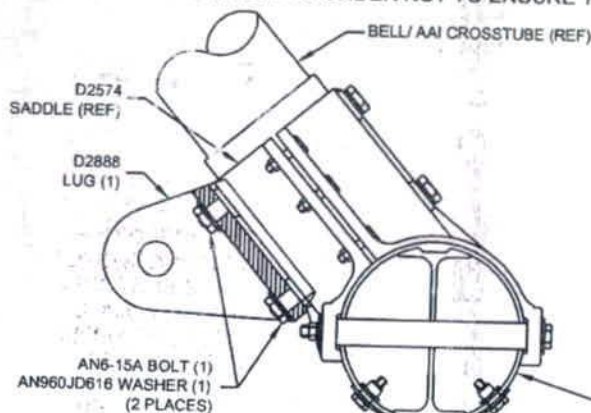


FIGURE 1
(BELL/AAI CROSSTUBES)

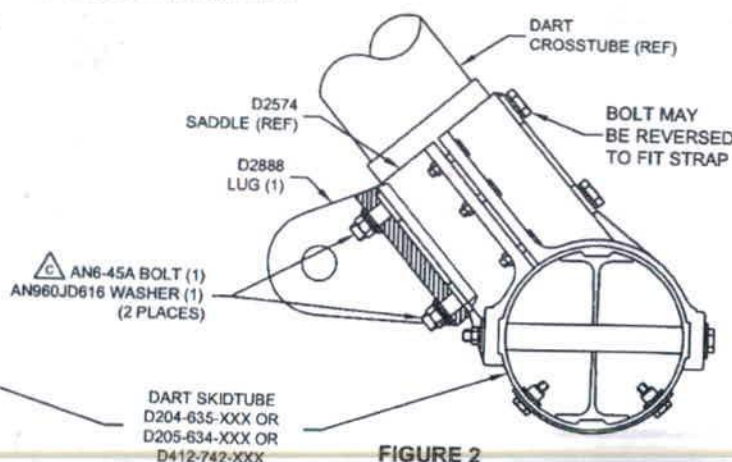


FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09			
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04			
A	NEW ISSUE	CP	99.05.03			
REV.	DESCRIPTION	BY	DATE			
DESIGN	    	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN						
CHECKED						
MFG. APPR.				N/A	DRAWING NO.	REV. C
APPROVED					D412-666	SHEET 1 OF 1
DE APPR.		TITLE	SCALE			
DATE	07.08.10	412 GROSS WEIGHT TOWING KIT	1:4			
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